

Work Order ID 59527

June 7, 2010 9:01:37 AM

Page 1

Item ID: D2175-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle LH

Start Date: 6/07/10 Start Qty: 7.00

Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 7.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2175

Rev E

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D2175 ☐ Dwg Rev: E ☐ Prog Rev: E ☐ 12-
Deburr if necessary

2024 . 063

B10-6-8



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-6-8

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8106605



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 59527

June 7, 2010 9:01:37 AM

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Item ID: D2175-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Angle LH					
Start Date: 6/07/10	Start Qty: 7.00		Cust Item ID:		
Required Date: 6/09/10	Req'd Qty: 7.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Small Fab	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Debur Stack	u/a 8							
140  Brake NC	NC BRAKE	0.00							
Brake NC	Memo	0.00							
	Form as per Dwg D2175								
150  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							

SB 10/06/09 (7)

(#2) 7
-1

W/O:		WORK ORDER CHANGES					
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Work Order ID 59527

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Item ID: D2175-1

Accept



Setup Start



Revision ID:

Item Name: Angle LH

Stop



Start Date: 6/07/10

Start Qty: 7.00



Cust Item ID:

Required Date: 6/09/10

Req'd Qty: 7.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7

BR 10-6-10

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/06/10

7

φ

180

Identify as per dwg & Stock Location: 204

0.00



Packaging

Memo

0.00

Packaging

10-6-10

7A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 59527

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June 7, 2010 9:01:38 AM

Item ID: D2175-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Angle LH

Start Date: 6/07/10 Start Qty: 7.00



Cust Item ID:

Required Date: 6/09/10 Req'd Qty: 7.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/11 *[Signature]*
MLF
10-6-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

June 7, 2010 9:01:36 AM

Page 1

Work Order ID: 59527



Parent Item: D2175-1



Parent Item Name: Angle LH

Start Date: 6/07/10

Required Date: 6/09/10

Comments: IPP ☐ E ☐ 04.06.09 ☐ Reformat ☐ KJ/RF
 IPP Rev:F 06-04-28 Manufactured on Water Jet JLM
 IPP Rev:G As per Rev E 06-11-22 JLM ☐

Start Qty: 7.00

Required Qty: 7.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Qty per Kit	Total	Qty	Date	Status
M2024T3S.063		Purchased	No			100	sf	144.2000	0.4722	3.479368			



2024-T3 .063 sheet



18106-8

Location

Loc Qty

Loc Code

MAT22

144.2

111787

2

113866

19.2

114351

123

~~111787~~ x 6 = 0.8

~~114351~~ x 7 = 2.8

56

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	59527
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓			
R0.35	+/-0.030	.35	✓			
2.915	+/-0.010	2.921	✓			
50°	+/-0.5°	50°	✓			
0.300	+/-0.010	.300	✓			
1.050 Pitch	+/-0.010	1.049	✓			
10.500	+/-0.010	10.510	✓			
11.550	+/-0.010	11.560	✓			
0.550	+/-0.010	.549	✓			
0.900	+/-0.010	.905	✓			
0.063 thick	+/-0.010	.065	✓			
Grain Direction	N/A		✓			
Ø0.128	+0.005/-0.001	.129	✓			
Ø0.172	+0.005/-0.001	.173	✓			

Measured by:	IB
Date:	10-6-8

Audited by:	S
Date:	10/06/08

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

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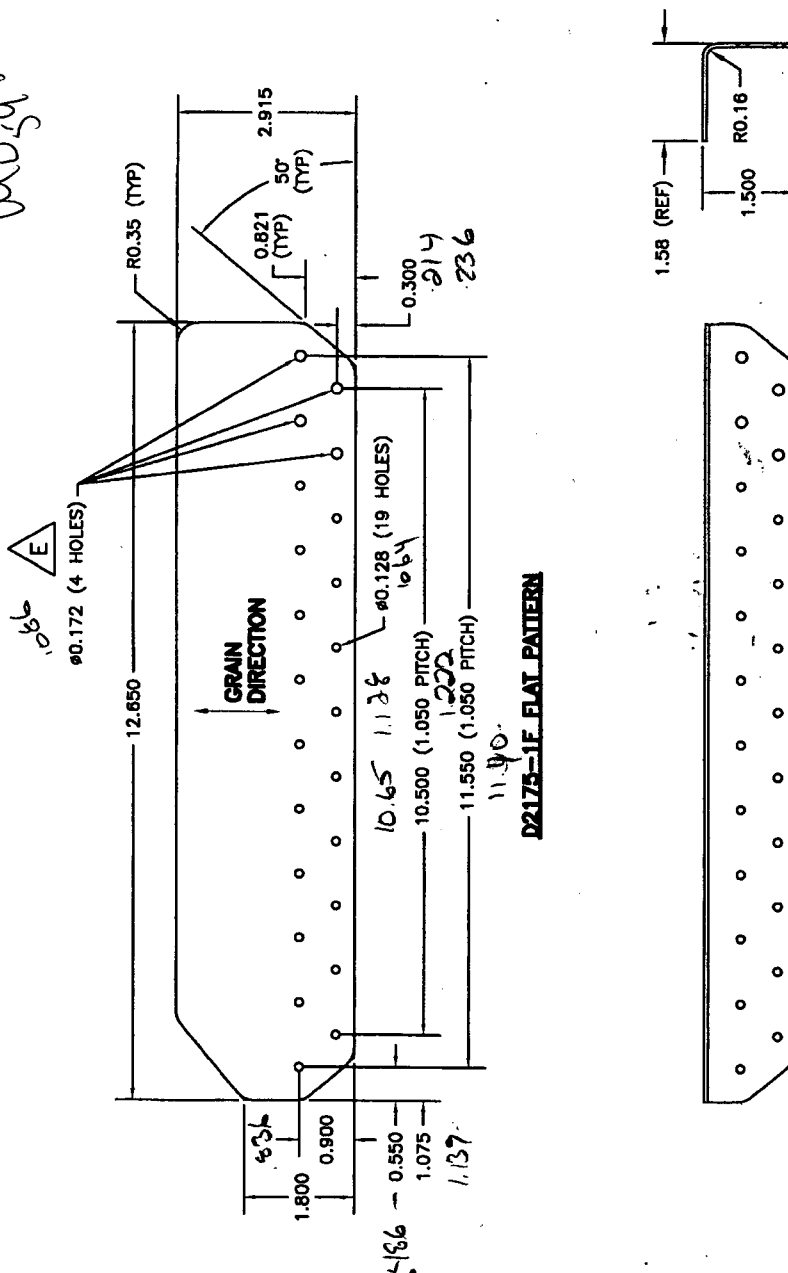
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DESIGN RF		DRAWN BY LE		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH		APPROVED [Signature]		DRAWING NO. D2175 REV. E SHEET 1 OF 1	
DATE 06.09.25		TITLE ANGLE		SCALE 1:3	
A	95.10.25	NEW ISSUE			
B	96.01.18	CHANGED DIMENSION			
C	00.09.11	UPDATE FINISH SPEC			
D	04.06.03	RE-DESIGN			
E	06.09.25	INC HOLE DIA TO $\varnothing 0.172$, 4 HOLES			

RELEASED
06 10 13



D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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